



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3393-1

Job Sheet 176888

Part No: D3393-1

Job Qty: 4 ea

Part Name: Battery Lock Casing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/21/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP A 05.02.18 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/21/18	5/21/18	0.00	0.00	Start Up Machining-2		DAS 18/06/01
100	Bandsaw	4 pcs	5/21/18	5/21/18	0.00	0.01	Bandsaw1		52 18/06/01
110	CNC Vertical Machining	4 pcs	5/21/18	5/21/18	0.33	2.05	HAAS1-3		9-89 18/06/01
130	QC	4 pcs	5/21/18	5/21/18	0.00	0.00	QC8 Machining-2		72 18/06/01
140	HandFinish	4 pcs	5/21/18	5/21/18	0.00	0.12	HandFinish1		SA 18-06-04
150	Powdercoat	4 pcs	5/21/18	5/21/18	0.00	0.15	Powdercoat6		BL 18-6-11
160	QC	4 pcs	5/21/18	5/21/18	0.00	0.00	QC3		
170	Packaging	4 pcs	5/21/18	5/21/18	0.00	0.00	Packaging3-1		DAS 5/501 6 JUN 11 2018
180	QC21-SA	4 Ea	5/21/18	5/21/18	0.00	0.00	QC21		9-89 ML5 JUN 11 2018

Part Op 100 - Cut blank: 1.500" x 1.500" x 3.125" long

Descriptions: 110 - Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1

150 - START TIME: 11:10

OUT: 300 FINISH: 11:40 M129223

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X01.500	6061-T6 Bar 1.50 X 1.50	1.0832 ft (.2708 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X01.500	1	15	0

5033413 → 2.61 pi. → 5077009



Container No: S077011



Part: D3393-1

Job No: 176888

Serial No/Batch: S077011

Revision:

Inspector:

Exp Date: 06/01/2018

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/01/18

5/3/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Battery Lock Casing	0.750Inches ± 0.010	0.760 0.740	Diameter	.751
2	Battery Lock Casing	0.625Inches ± 0.010	0.635 0.615		.627
3	Battery Lock Casing	1.250Inches ± 0.010	1.260 1.240	Diameter	1.244
4	Battery Lock Casing	1.088Inches ± 0.010	1.098 1.078		1.088
5	Battery Lock Casing	0.734Inches ± 0.010	0.744 0.724	Diameter	.740
6	Battery Lock Casing	2.658Inches ± 0.010	2.668 2.648		2.655
7	Battery Lock Casing	1.550Inches ± 0.010	1.560 1.540		1.550
8	Battery Lock Casing	0.125Inches ± 0.010	0.135 0.115		0.125
9	Battery Lock Casing	45.000Degrees ± 5.000	50.000 40.000	Angle	45°
10	Battery Lock Casing	1.500Inches ± 0.030	1.530 1.470		1.490
11	Battery Lock Casing	0.750Inches ± 0.010	0.760 0.740		.750
12	Battery Lock Casing	1.050Inches ± 0.010	1.060 1.040	Diameter	1.050
13	Battery Lock Casing	1.000Inches ± 0.010	1.010 0.990	Diameter	.994
14	Battery Lock Casing	0.338Inches ± 0.010	0.348 0.328		.338
15	Battery Lock Casing	0.563Inches ± 0.010	0.573 0.553		.560
16	Battery Lock Casing	0.100Inches + 0.000 - 0.010	0.100 0.090		.098
17	Battery Lock Casing	3.000Inches ± 0.030	3.030 2.970		3.005
18	Battery Lock Casing	1.500Inches ± 0.010	1.510 1.490		1.490
19	Battery Lock Casing	0.375Inches ± 0.010	0.385 0.365		.375
20	Battery Lock Casing	1.250Inches ± 0.030	1.280 1.220		1.248
21	Battery Lock Casing	0.125Inches ± 0.010	0.135 0.115		.125
22	Battery Lock Casing	30.000Degrees ± 0.500	30.500 29.500	Angle	30°

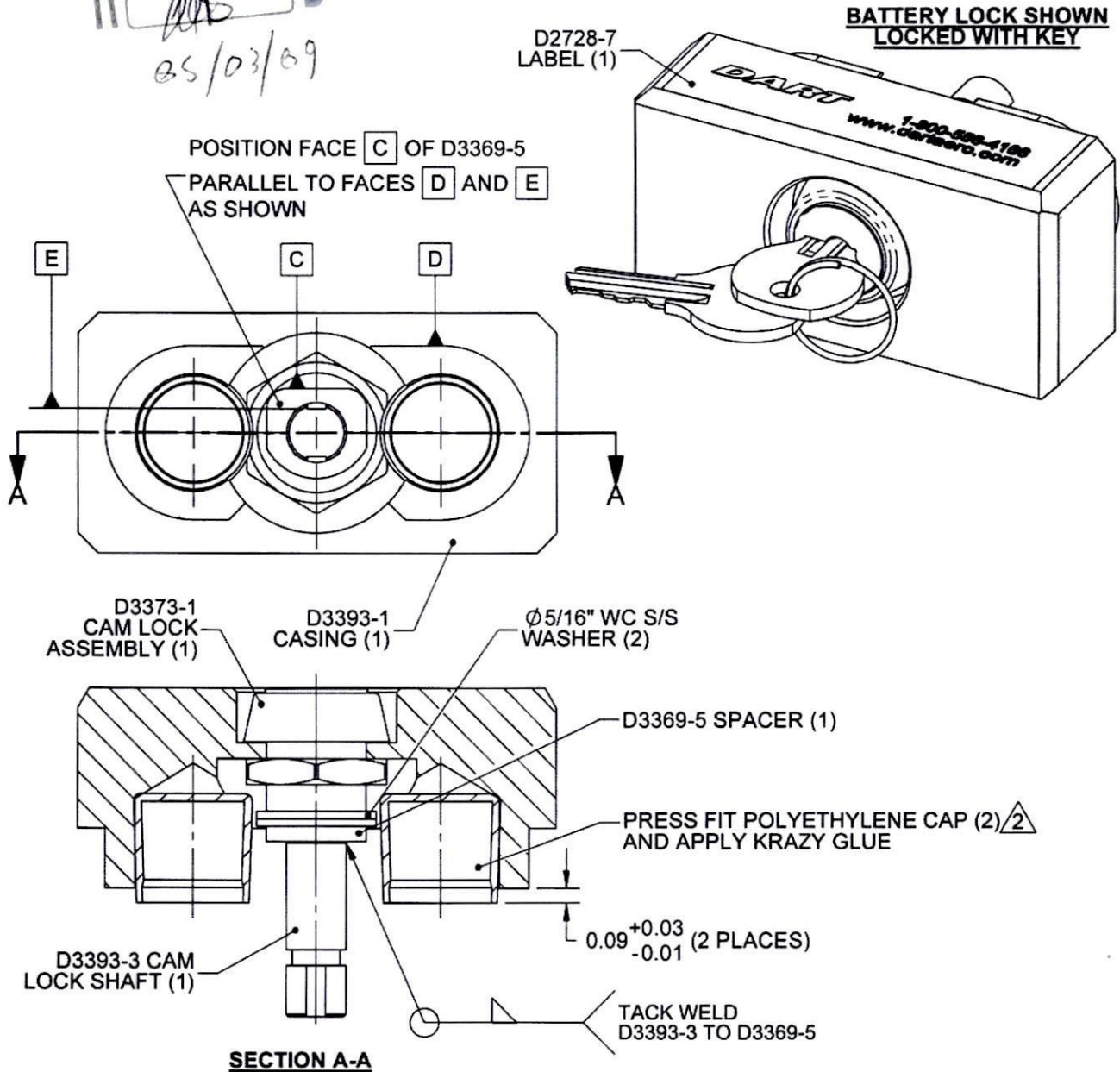
Plex 5/3/18 2:45 PM Dart.Gagnon.Michelle

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

**D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

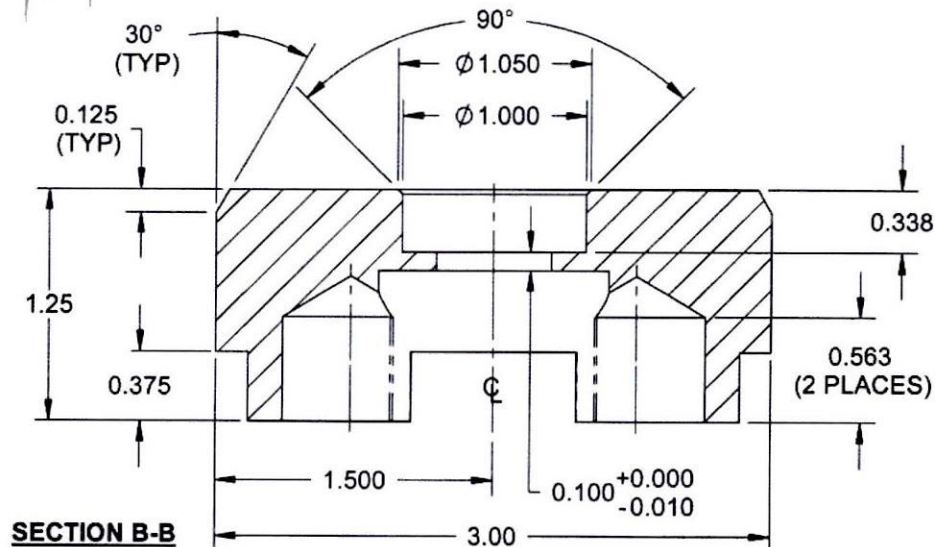
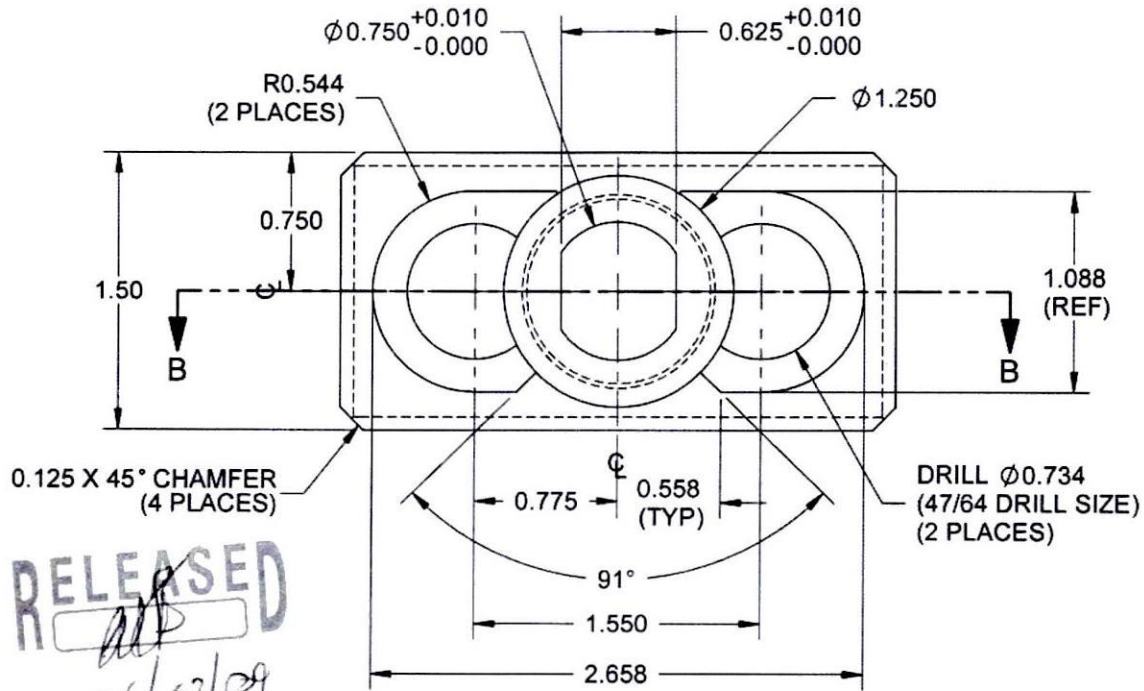
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 43	APPROVED 43	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK	SCALE 1:1	

**D3393-1 CASING****NOTES:**

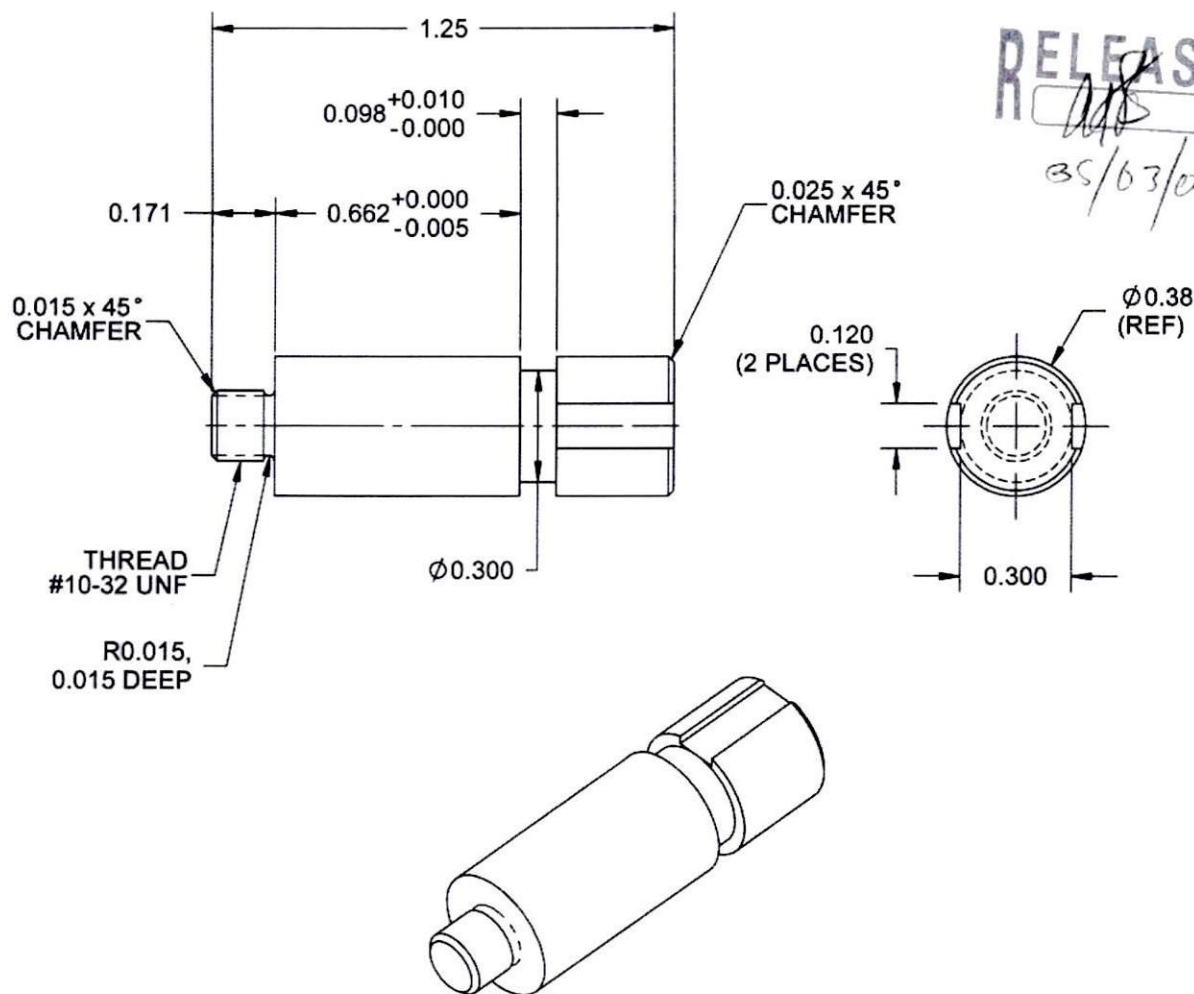
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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